



Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

AEROSPACE MATERIAL SPECIFICATION

AMS 4130H

Superseding AMS 4130G

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UNS A92025

ALUMINUM ALLOY FORGINGS
4.4Cu - 0.85Si - 0.80Mn (2025-T6)

1. SCOPE:

1.1 Form: This specification covers an aluminum alloy in the form of die forgings and forging stock.

1.2 Application: Primarily for complex-shaped parts requiring moderate strength and good forgeability of the material. Certain design and processing procedures may cause this material to be susceptible to stress-corrosion cracking; ARP 823 recommends practices to minimize such conditions.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) and Aerospace Recommended Practices (ARP) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2201 - Tolerances, Aluminum and Aluminum Alloy Bar, Rod, Wire, and Forging Stock, Rolled or Drawn

AMS 2350 - Standards and Test Methods

AMS 2375 - Approval and Control of Critical Forgings

AMS 2630 - Ultrasonic Inspection

AMS 2645 - Fluorescent Penetrant Inspection

AMS 2808 - Identification, Forgings

2.1.2 Aerospace Recommended Practices:

ARP 823 - Minimizing Stress Corrosion Cracking in Wrought Heat Treatable Aluminum Alloy Products

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM B557 - Tension Testing Wrought and Cast Aluminum and Magnesium Alloy Products

ASTM E10 - Brinell Hardness of Metallic Materials

ASTM E34 - Chemical Analysis of Aluminum and Aluminum-Base Alloys

2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Federal Standards:

Federal Test Method Standard No. 151 - Metals; Test Methods

2.3.2 Military Specifications:

MIL-H-6088 - Heat Treatment of Aluminum Alloys

* This specification was editorially corrected October 13, 1977.

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2.3.3 Military Standards:

MIL-STD-649 - Aluminum and Magnesium Products, Preparation for Shipment and Storage

3. TECHNICAL REQUIREMENTS:

- 3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E34, by spectrographic methods in accordance with Federal Test Method Standard No. 151, Method 112, or by other approved analytical methods:

		min	max
Ø	Copper	3.90	5.0
	Silicon	0.50	1.2
	Manganese	0.40	1.2
	Iron	--	1.0
	Zinc	--	0.25
	Titanium	--	0.15
	Chromium	--	0.10
	Magnesium	--	0.05
	Other Impurities, each	--	0.05
	Other Impurities, total	--	0.15
	Aluminum	remainder	

- 3.2 Condition: The product shall be supplied in the following condition:

- 3.2.1 Forgings: Solution and precipitation heat treated in accordance with MIL-H-6088.

- 3.2.2 Forging Stock: As ordered by the forging manufacturer.

- 3.3 Properties: The product shall conform to the following requirements:

3.3.1 Forgings:

- Ø 3.3.1.1 Tensile Properties: Shall be as follows, determined in accordance with ASTM B557:

- 3.3.1.1.1 Test Specimens: Test specimens, machined from separately-forged coupons or from forging stock representing the forgings and, in either case, heat treated with the forgings or machined from prolongations on heat treated forgings, shall have the following properties:

Tensile Strength, min	55,000 psi	(379 MPa)
Yield Strength at 0.2% Offset, min	33,000 psi	(228 MPa)
Elongation in 2 in. (50.8 mm) or 4D, min	16%	

- 3.3.1.1.2 Forgings, With Grain Flow: Test specimens, machined from forgings not over 4 in. (102 mm) in nominal thickness with the axis of specimen in the area of gage length within 15 deg (0.262 rad) of parallel to the forging flow lines, shall have properties as specified in 3.3.1.1.1 except that elongation may be as low as 11%, unless otherwise agreed upon by purchaser and vendor.

- 3.3.1.1.3 Forgings, Across Grain Flow: Test specimens, machined from forgings whose length is not greater than 4 times the thickness with the axis of specimen in the area of gage length varying more than 15 deg (0.262 rad) from parallel to the forging flow lines, shall have the following properties:

Tensile Strength, psi	52,000 psi	(358 MPa)
Yield Strength at 0.2% Offset, min	32,000 psi	(221 MPa)
Elongation in 2 in. (50.8 mm) or 4D, min	8%	

- 3.3.1.2 Hardness: Should be not lower than 100 HB/10/500, 100 HB/14.3/1000, or 106 HB/10/1000, determined in accordance with ASTM E10, but forgings shall not be rejected on the basis of hardness if the tensile property requirements are met.
- 3.3.2 Forging Stock: When a sample of stock is forged to a test coupon and heat treated in the same manner as forgings, specimens taken from the heat treated coupon shall conform to the requirements of 3.3.1.1.1 and 3.3.1.2. If specimens taken from the stock after heat treatment in the same manner as forgings conform to the requirements of 3.3.1.1.1 and 3.3.1.2, the tests shall be accepted as equivalent to tests of a forged coupon. The forging stock supplier, however, shall not be required to conduct such tests.
- 3.4 Quality: The product, as received by purchaser, shall be uniform in quality and condition, clean, sound, and free from foreign materials and from internal and external imperfections detrimental to usage of the product.
- 3.4.1 When specified, forgings shall be subjected to fluorescent penetrant inspection in accordance with AMS 2645 and/or to ultrasonic inspection in accordance with AMS 2630. Standards for acceptance shall be as agreed upon by purchaser and vendor.
- 3.5 Tolerances: Unless otherwise specified, tolerances for forging stock shall conform to all applicable requirements of AMS 2201.
4. QUALITY ASSURANCE PROVISIONS:
- 4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the product conforms to the requirements of this specification.
- 4.2 Classification of Tests:
- 4.2.1 Acceptance Tests: Tests of the product to determine conformance to composition (3.1) requirements and of forgings to determine conformance to tensile property (3.3.1) requirements are classified as acceptance tests.
- 4.2.2 Periodic Tests: Tests of forgings to determine conformance to hardness (3.3.1.2) requirements and of forging stock to determine ability to develop required properties (3.3.2) are classified as periodic tests.
- 4.2.3 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests.
- 4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.
- 4.3 Sampling: Shall be as follows; a lot shall be all forgings of the same part number, size, or nominal cross-section and configuration heat treated in the same batch furnace load or in a continuous furnace consecutively during an 8-hr period.
- 4.3.1 Composition: At least one sample shall be taken by the producer from each group of ingots poured simultaneously from the same source of molten metal.
- 4.3.1.1 Unless compliance with 4.3.1 is established, an analysis shall be made for each 6000 lb (2724 kg) or less of material comprising the lot except that not more than one analysis shall be required per piece.
- 4.3.2 Tensile Properties:

4.3.2.1 Forgings: At least one separately-forged coupon or one forging prolongation, heat treated with each lot of forgings, shall be tested.

4.3.2.1.1 In lieu of a prolongation or separately-forged coupon, tensile tests shall be conducted on specimens cut, in locations designated on the drawing, from a forging representing each lot.

4.4 Approval: When specified, approval and control of forgings shall be in accordance with AMS 2375.

4.5 Reports:

4.5.1 The vendor of forgings shall furnish with each shipment three copies of a report stating that the chemical composition conforms to the requirements of this specification and showing the results of tests on each lot to determine conformance to the other acceptance test requirements of this specification. This report shall include the purchase order number, material specification number and its revision letter, size or part number, and quantity.

4.5.2 The vendor of forging stock shall furnish with each shipment three copies of a report stating that the chemical composition of the stock conforms to the requirements of this specification. This report shall include the purchase order number, material specification number and its revision letter, size, and quantity.

4.5.3 The vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number and its revision letter, contractor or other direct supplier of forgings, part number, and quantity. When forgings for making parts are produced or purchased by the parts vendor, that vendor shall inspect each lot of forgings to determine conformance to the requirements of this specification, and shall include in the report a statement that the forgings conform, or shall include copies of laboratory reports showing the results of tests to determine conformance.

4.6 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the product may be based on the results of testing two additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the product represented and no additional testing shall be permitted. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

5.1 Identification: The product shall be identified as follows:

5.1.1 Forgings: In accordance with AMS 2808.

5.1.2 Forging Stock: As agreed upon by purchaser and vendor.

5.2 Packaging:

5.2.1 The product shall be prepared for shipment in accordance with commercial practice to ensure carrier acceptance and safe transportation to the point of delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

5.2.2 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-649, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.2.1 will be acceptable if it meets the requirements of Level C.

6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

7. REJECTIONS: Material not conforming to this specification or to authorized modifications will be subject to rejection.